

Date: Tuesday, 17/02/2009 10:18:34 AM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 45817		
Estimate Number	: 11178		
P.O. Number	:	Part Number	: D32931
This Issue	: 17/02/2009 S.O. No. :	Drawing Number	: D3293 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 44134	Material	:
Written By	:	Due Date	: 10/03/2009 Qty: 12 Um: Each
Checked & Approved By	: <u>JLD 09.02.17</u>		
Comment	: Est:A 04.08.24 New issue KJ/JLM		
	: Est Rev:B Now on Waterjet 06-11-02 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S080	2024-T3 .080 sheet
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Comment: Qty.: 1.9177 sf(s)/Unit Total : 23.0126 sf(s)
Material: 2024-T3 (QQ-A-250/4) 0.080" thick
(M2024T3S.080)
Identify for D3293-1
Batch: 110908

ml 09 03 16

(12)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D3293
Dwg Rev: A
Prog Rev: A

2-Deburr if necessary

ml 09 03 16

(12)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 09 03 16

(12)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 09/03/16 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 17/02/2009 10:18:34 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 45817

Part Number: D32931

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1- Deburr

u/a S

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/03/16 (12)

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

FL 09/03/17

(12)

8.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M105642

START TIME:

11:15

OVEN TEMPERATURE:

320

FINISH TIME:

11:45

BR 09-03-20

(12)

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

P 19/3/23 (12)

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: SD11

P 09/3/23 (12)

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/24

Job Completion



MF 09-03-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 45817
Description: Doubler		Part Number: D3293-1
Inspection Dwg: D3293 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST





☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.350	+/-0.010	0.350	✓		VEN	
0.650	+/-0.010	0.660	✓		VEN	
1.874	+/-0.010	1.881	✓		VEN	
Ø0.141	+0.005/-0.001	0.141	✓		VEN	
Ø0.128	+0.005/-0.001	0.128	✓		VEN	
17.750	+/-0.010	17.750	✓		MT	
20.15	+/-0.030	20.15	✓		MT	
R0.350	+/-0.010	R0.350	✓		VEN	
R0.312	+/-0.010	R0.312	✓		VEN	
0.080	+/-0.010	0.077	✓		VEN	

Measured by: M.M	Audited by: S	Prototype Approval:	N/A
Date: 09.03.16	Date: 09/03/16	Date:	N/A

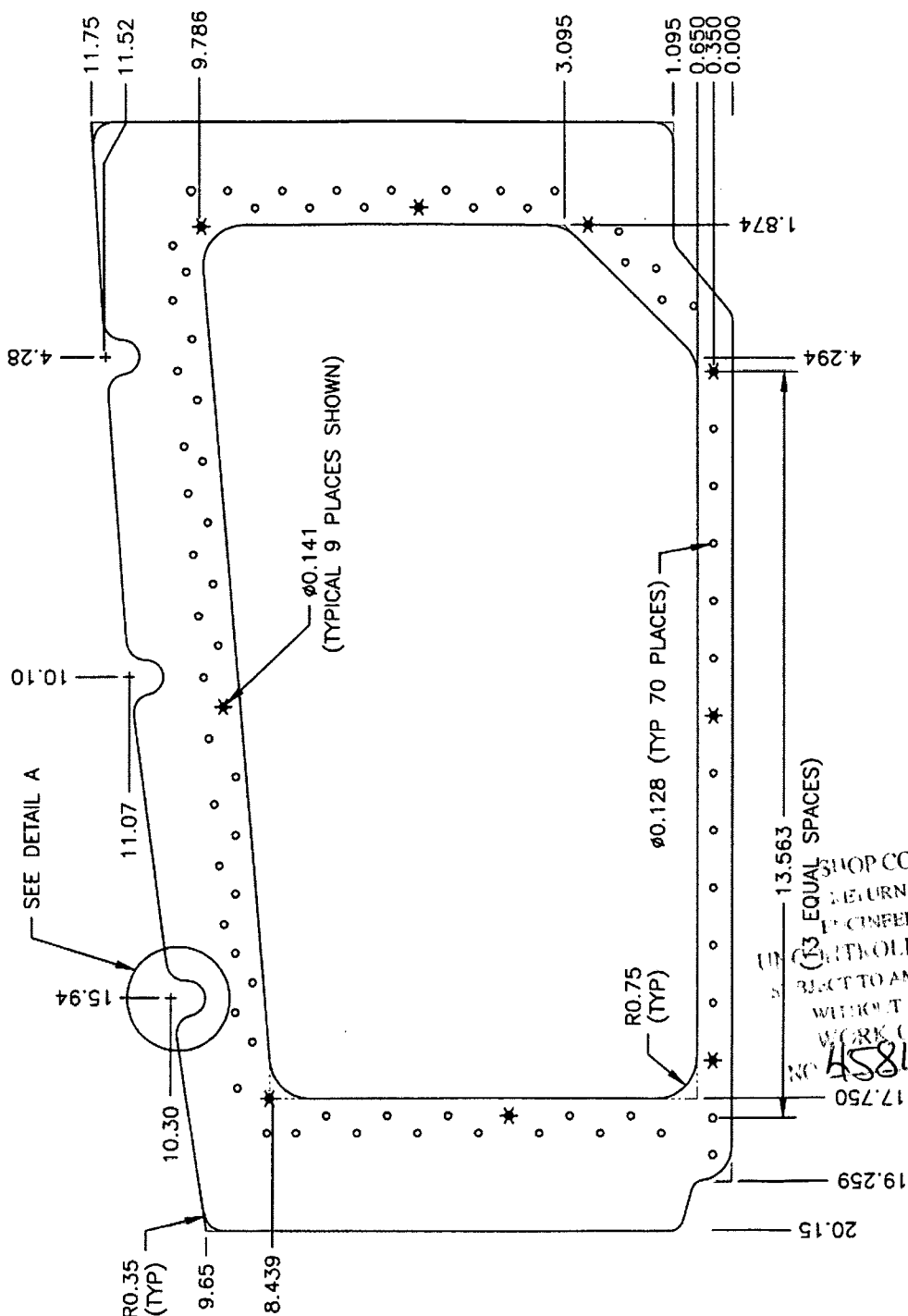
Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	KJ/JLM	
B	08.10.09	0.080 dimension added	KJ/DD	



DESIGN 		DRAWN BY 		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 		APPROVED 		DRAWING NO. REV. A D3293 SHEET 1 OF 1	
DATE 04.06.28		TITLE DOUBLER		SCALE 1:3	
A	04.06.28		NEW ISSUE		

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12



13.56 EQUAL SHIP COPY
RETURN TO
CONFERRING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 45817

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